

Date: Friday, 6/29/2007 11:17:48 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JACK SADDLE
Job Number : 33258	
Estimate Number : 11177	
P.O. Number : <u>N/A</u>	Part Number : D2281
This Issue : 6/29/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2281 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : G
Previous Run : 29808	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 7/12/2007 Qty: 100 U/m: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev A Removed from 9 Digit 05-12-02 JLM	
Est: rev B 06.07.17 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS .080
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Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s)

304SS .080

batch: 11101813 X

2.0	WATER JET	FLOW WATER JET
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m/B 07-07-03



Comment: FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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m/B 07-07-03



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/07/04

counted
X/00

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Deburr

[Signature] 07/07/04 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 6/29/2007 11:17:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 33258

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 07/07/09

(100)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

QSP 12

En 07/07/10

(100)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

lg 07/07/11

(100)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/12

(100)

Job Completion



u 07-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33258
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.478	✓		VERN	
4.114	+/-0.010	4.114	✓		VERN	
2.933	+/-0.010	2.933	✓		VERN	
1.535	+/-0.010	1.545	✓		VERN	
0.354	+/-0.010	.364	✓		VERN	
0.354	+/-0.010	.364	✓		VERN	
0.604	+/-0.010	.604	✓		VERN	
2.000	+/-0.010	2.005	✓		VERN	
3.396	+/-0.010	3.396	✓		VERN	
3.646	+/-0.010	3.646	✓		VERN	
4.000	+/-0.010	4.010	✓		VERN	
1.525	+/-0.010	1.535 1.535	✓		VERN	
2.475	+/-0.010	2.475	✓		VERN	
Ø0.323	+0.006/-0.001	.325	✓		VERN	
0.080	+/-0.010	.080	✓		VERN	

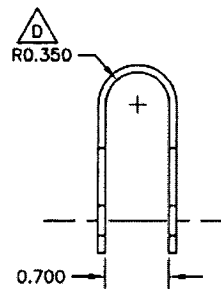
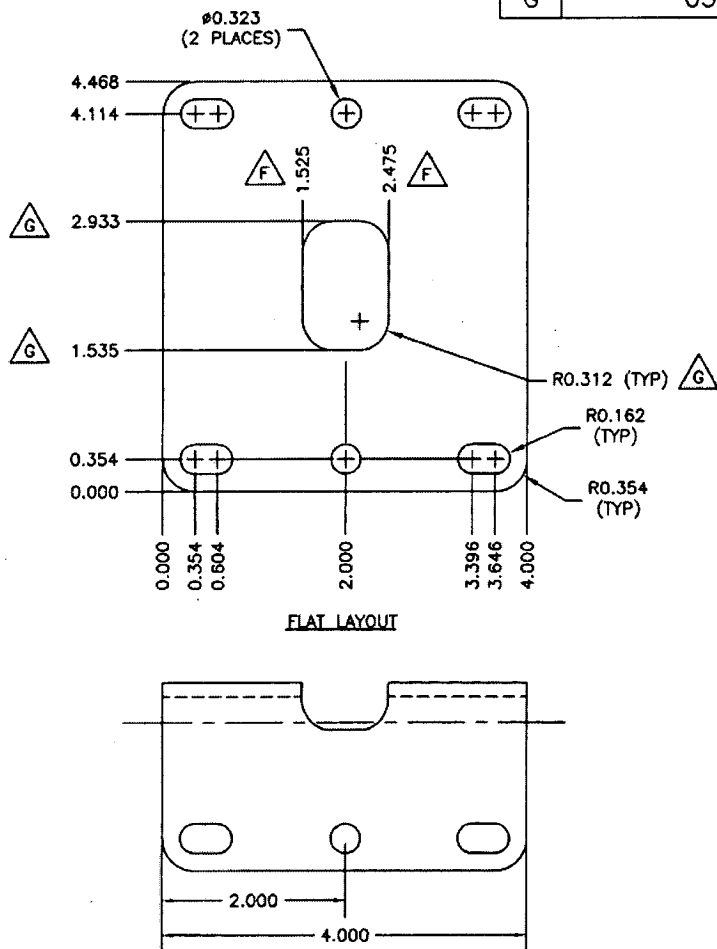
Measured by: <u>BS/m</u>	Audited by: <u>En</u>	Prototype Approval:	N/A
Date: <u>07-07-03</u>	Date: <u>07/27/04</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	<u>[Signature]</u>



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE

WORK ORDER
NO. *33258*

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